



Dart Aerospace Ltd.  
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**RB T103217-101-1**  
**Job Sheet 184573**



**Part No:** RB T103217-101-1

**Job Qty:** 1 ea

**Part Name:** Body



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 10/12/18

**Job Tracking No:**

**Due Date:** 10/19/18

**Created By:** Linda Lacelle

**Type:** AOG

**Description:**

**Note:** DWG RB T103217-101 Rev. D IPP Rev. A 18.08.14 new issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off          |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                   |
| 90    | Start up Operation | 1 Ea  | 10/19/18   | 10/19/18 | 0.00      | 0.00    | Start Up Machining-3  |           | DAS 56 9-89 10-14 |
| 120   | CNC Lathe          | 1 pcs | 10/19/18   | 10/19/18 | 0.00      | 1.00    | MORI SL2500Y          |           | 9-89 10-14        |
| 130   | QC                 | 1 pcs | 10/19/18   | 10/19/18 | 0.00      | 0.00    | QC2 Machining-4       |           | 9-89 10-14        |
| 140   | QC                 | 1 pcs | 10/19/18   | 10/19/18 | 0.00      | 0.00    | QC8 Machining-4       |           | 9-89 10-14        |
| 170   | Outsource          | 1 pcs | 10/19/18   | 10/19/18 |           |         | GRO002-VC             | 10        | 9-89 10-14        |
| 180   | Packaging          | 1 pcs | 10/19/18   | 10/19/18 | 0.00      | 0.00    | Packaging2            |           | DAS 21 9-89 10-14 |
| 190   | QC                 | 1 pcs | 10/19/18   | 10/19/18 | 0.00      | 0.00    | QC6                   |           | 9-89 10-14        |
| 200   | Packaging          | 1 pcs | 10/19/18   | 10/19/18 | 0.00      | 0.00    | Packaging3-1          |           | 9-89 10-14        |
| 210   | QC21-SA            | 1 Ea  | 10/19/18   | 10/19/18 | 0.00      | 0.00    | QC21                  |           | DAS 21 9-89 10-14 |

Part Op 120 - 1-Machine as per DWG. FC329 FOLIO REV: 2 -Deburr  
Descriptions: 170 - -Issue P/O to Groupe Altech; PO 5083256 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of  
Conformity is required

### Job BOM

| Part / Item | Component Name     | Quantity    | Operation             | Container                     |
|-------------|--------------------|-------------|-----------------------|-------------------------------|
| D6104-007   | Round Billet, 17-4 | 1 Ea (1 ea) | 90-Start up Operation | 2.625 5094 657 (STRESS PROOF) |
|             |                    |             |                       | 5083256 1X 6104-007           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D6104-007      | 1        | 27        | 0         |

### Part Specifications



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und.

**Container No:** S118080



**Part:** RB T103217-101-1

**Job No:** 184573

**Serial No/Batch:** S118080

**Revision:** D

**Inspector:**

**Exp Date:**

**Instructions:**

Date: 10/14/18

Plex 10/12/18 8:50 AM dart.lacelle.linda

## Linda Lacelle

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**From:** Michael Lee  
**Sent:** Friday, October 12, 2018 9:19 AM  
**To:** Linda Lacelle; Ketan Tailor  
**Cc:** Jean-Luc Menard; Guillaume Auclair; Mathieu Lamarche  
**Subject:** Re: rb t103217-101-1

Good Morning Linda,

I do not see and major issues with the proposed deviation.  
303/304/316 would also be acceptable for this tool.

I will sign off the deviation on the work order on Monday if that works ?

Cheers,

Mike

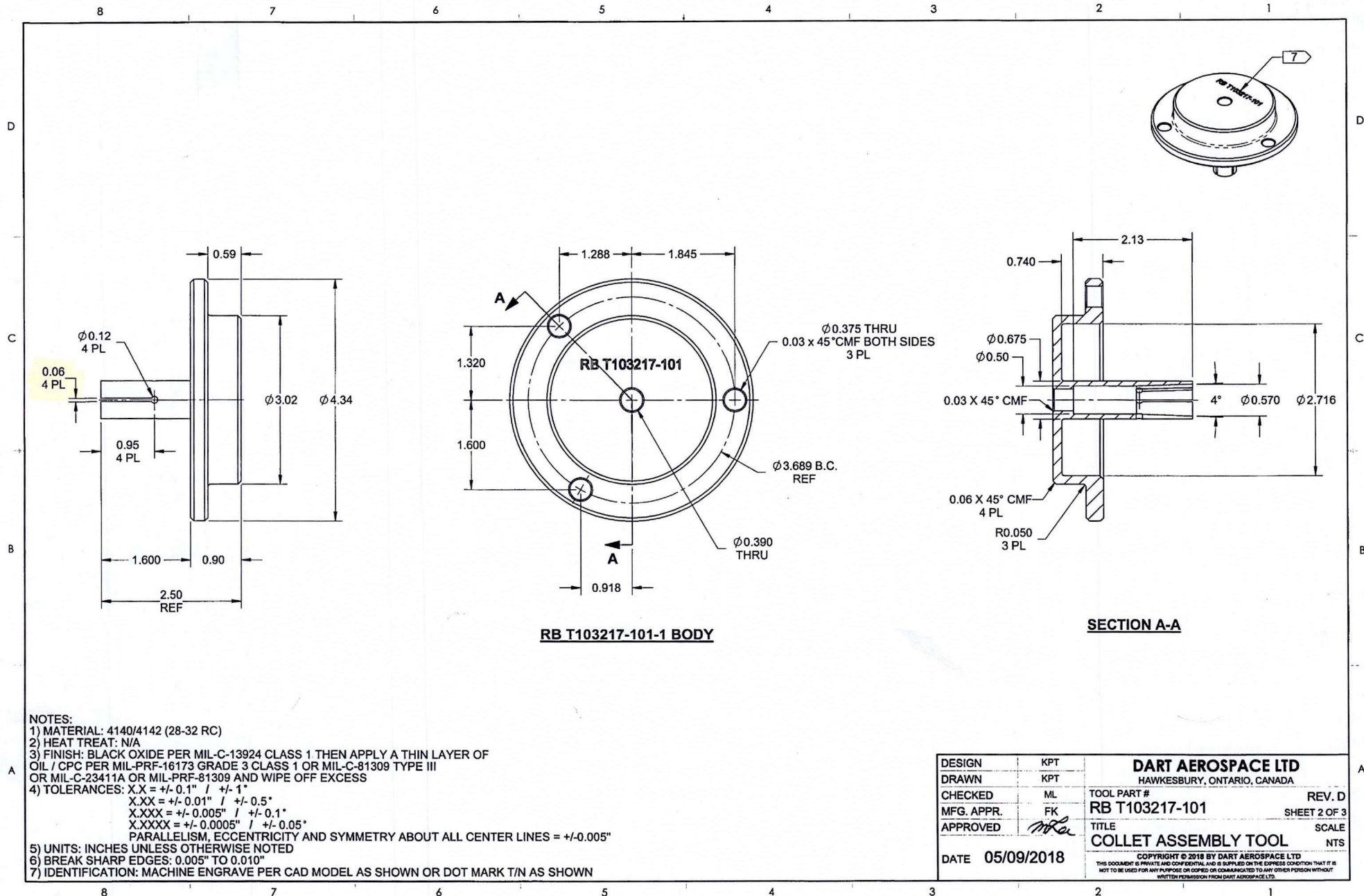
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**From:** Linda Lacelle  
**Sent:** Friday, October 12, 2018 9:03:07 AM  
**To:** Michael Lee  
**Cc:** Jean-Luc Menard; Guillaume Auclair; Mathieu Lamarche  
**Subject:** rb t103217-101-1

Mike,  
We have an urgent order (replacement for shipping the wrong part AGAIN) and would like to use D6104-007. Can you please let us know asap, if we can use as a deviation

Thx  
L





|                                         |               |                                      |
|-----------------------------------------|---------------|--------------------------------------|
| <b>DART AEROSPACE LTD</b>               |               | <b>Work Order:</b> 784573            |
| <b>Description:</b> BODY                |               | <b>Part Number:</b> RBT 103217-101-1 |
| <b>Inspection Dwg:</b> RBT 103217-101-1 | <b>Rev:</b> D | <b>Page 1 of 1</b>                   |

### INSPECTION SHEET

| Drawing Dimension | Tolerance               | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-------------------------|------------------|--------|--------|----------------------|----------|
| 2.59              | $\pm .010$              | .592             | ✓      |        |                      |          |
| 3.02              | $\pm .010$              | 3.02             | ✓      |        |                      |          |
| 4.34              | $\pm .010$              | 4.34             | ✓      |        |                      |          |
| 0.90              | $\pm .010$              | .901             | ✓      |        |                      |          |
| 2.50 REF          | $\pm .010$              | 2.501            | ✓      |        |                      |          |
| 1.600             | $\pm .005$              | 1.598            | ✓      |        |                      |          |
| 0.95              | $\pm .010$              | .955             | ✓      |        |                      |          |
| 0.06              | $\pm .010$              | .065             | ✓      |        |                      |          |
| 0.12              | $\pm .010$              | .127             | ✓      |        |                      |          |
| 1.320             | $\pm .005$              | 1.321            | ✓      |        |                      |          |
| 1.600             | $\pm .005$              | 1.601            | ✓      |        |                      |          |
| 1.288             | $\pm .005$              | 1.2885           | ✓      |        |                      |          |
| 1.845             | $\pm .005$              | 1.846            | ✓      |        |                      |          |
| 0.918             | $\pm .005$              | .9195            | ✓      |        |                      |          |
| 0.375             | $\pm .005$              | .377             | ✓      |        |                      |          |
| 0.03 x 45° 8x     | $\pm .010 \pm .5^\circ$ | .028 x 45°       | ✓      |        |                      |          |
| 3.689 REF         | $\pm .005$              | 3.6915           | ✓      |        |                      |          |
| 0.390             | $\pm .005$              | .392             | ✓      |        |                      |          |
| 0.03 x 45°        | $\pm .010 \pm .5^\circ$ | .03 x 45°        | ✓      |        |                      |          |
| 0.50              | $\pm .010$              | .502             | ✓      |        |                      |          |
| 0.675             | $\pm .005$              | .6725            | ✓      |        |                      |          |
| 0.740             | $\pm .005$              | .7425            | ✓      |        |                      |          |
| 2.13              | $\pm .010$              | 2.136            | ✓      |        |                      |          |
| 4°                |                         |                  |        |        |                      |          |
| 0.570             | $\pm .005$              | .568             | ✓      |        |                      |          |
| 2.716             | $\pm .005$              | 2.7185           | ✓      |        |                      |          |
| R.05 3x           | $\pm .010$              | .05              | ✓      |        |                      |          |
| .06 x 45° 4x      | $\pm .010 \pm .5^\circ$ | .058 x 45°       | ✓      |        |                      |          |

|                         |                       |                      |
|-------------------------|-----------------------|----------------------|
| <b>Measured by:</b> PMP | <b>Checked by:</b> Jm | <b>QC Inspector:</b> |
| <b>Date:</b> 2008-10-14 | <b>Date:</b> 18/10/15 | <b>Date:</b>         |

|                                                |              |
|------------------------------------------------|--------------|
| <b>Engineering Approval:</b><br>(If necessary) | <b>Date:</b> |
|------------------------------------------------|--------------|

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 14.07.31 | New Issue | KJ         |          |